



# Q-REFINISH BUMPER REPAIR

## INSTRUCTIONS

### PREPARATION

1. Wash the area to be treated, preferably with a high-pressure cleaner and degreaser
2. Clean the area with Colormatic Plastic Cleaner 50003-20, using Q-

Refinish cleaning cloths 60-160. **Note!** It is important to ensure that all cleaner has evaporated before primer application.

### SAND THE DAMAGED AREA

3. Sand the area around the damage on outer surface with P180-P240, down to bare plastic. We recommend a 10-mm sander due to faster grinding and reduced heat generation on plastic.
4. Drill a hole in each end of the crack in the plastic.
5. Sand a V-joint between the two drilled holes. Make sure to leave a 3 to 5-mm space

free along the center of the crack, so that the glue will lie between the plastic surfaces.

### APPLICATION OF PRIMER

6. Apply Q-Refinish Plastic Primer (40-590-400) on both the outer and inner surfaces, in a very thin layer. Let the primer dry for a minimum of 15 min. (at 23 °C).
7. Apply Q-Refinish Masking Tape (10-105) to the inner surface

### IMPORTANT – BEFORE APPLYING GLUE

8. Once you have put the glue stick in the glue gun, it is VERY important to synchronize the components in the glue to ensure that both glue and hardener are well mixed before application. This can be done by pressing some glue and hardener onto a mixing board before you put the nozzle on the gun. When you can see hardener and glue emerging from the gun, attach the nozzle and

make sure to synchronize the components again. Feel free to press out the first cm length of glue to ensure that the product is mixed correctly. The first cm of glue is not always used.

## **APPLICATION OF GLUE**

9. Apply Q Refinish plastic glue 50-400-XXXX in the sanded crevice on the bumper. Keep the nozzle completely inserted in the glue during application to avoid air holes in the glue.

10. Place 50-408 Plastic Contouring Film on top of the glue and spread it out with a plastic spatula. (Plastic Contouring Film reduces the amount of air in the repair itself; in addition, you do not have to clean the plastic spatula afterwards.)

11. Once the glue has dried, turn the item over and remove the masking tape from the inner surface. 12. Then apply Q-Refinish 2K glue 50-400-6090 on the inner surface of the item;

afterwards, the repair can be strengthened with 50-400 reinforcement mesh if necessary (depending on the size and location of the damage – it is a good idea for areas near screws and major damage).

## **FINAL STEPS**

13. Sand the outer surface of the repair with P180-P240 and a 10-mm eccentric sander, e.g. CP7215 (preferably a 10-mm orbit machine. It provides a faster sanding and a smoother surface on the plastic.)

14. Fill any small pores and holes with Q-Refinish 20-030-1000 Multiflex Filler.

15. Then sand with P240-P320 before applying plastic primer and sanding the filler.

For further information, see the technical data sheets contact a LAKGRUPPEN technician.



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